

Date: Monday, 08/12/2008 1:53:29 PM  
User: Julie Dawson

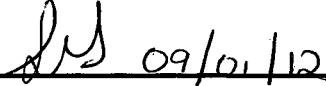
## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 43941B						
Estimate Number	: 10207						
P.O. Number	:			Part Number	: D2989043		
This Issue	: 08/12/2008	S.O. No.	:	Drawing Number	: D2989 REV D		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: LARGE FAB ASSY	Drawing Revision	: D		
Previous Run	: 43819B			Material	:		
Written By	:			Due Date	: 22/12/2008		
Checked & Approved By	: <u>JUL 08-12-08</u>			Qty:	1	Um:	Each
Comment	<p>: Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC Est Rev:L 08-12-02 revD as per dwg DD verified by:</p>						

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D29893	Rib 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: B 43996 → 1x  09/01/12
2.0	D29894	Rib 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: B 43997 → 1x  09/01/12
3.0	D29895	Rib 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: B 43998 → 2x  09/01/12
4.0	D298917	Rib 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: B 43994 → 1x  09/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 1:53:30 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43941B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D31821 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Hinge  
batch: B43293 → 2x

JM 09/01/12

6.0 D34423 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Shim  
batch: B42718 → 2x

JM 09/01/12

7.0 D3827041 Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Inboard)  
batch: B44011 → 1x

JM 09/01/12

8.0 D38325 Mesh (Lid)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Mesh (Lid)  
batch: B44014 → 1x

JM 09/01/13

9.0 D38335 Mesh (Lid End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Mesh (Lid End)  
batch: B44017 → 1x

JM 09/01/13

10.0 D3838041 Rib Assembly (Basket Lid, LH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Basket Lid, LH)  
batch: B44020 → 1x

JM 09/01/12

11.0 D3838042 Rib Assembly (Basket Lid, RH)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Rib Assembly (Basket Lid, RH)  
batch: B44021 → 1x

JM 09/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 1:53:30 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43941B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989 *SL*
- 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig *SL*
- 3- to locate hinges and shims use D2989-041, weld as per dwg D2989 *SL*

A/R ER316 S.S. Rod Batch: *M108775*

*SL 09/01/13 1x*

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*LPL09-01-13*

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*S09/01/13 X*

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*1 Plug holes prior to powder coating*

*2 Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989*

1ST COAT

START TIME:

*9:00 AM*

OVEN TEMPERATURE:

*400°F*

FINISH TIME:

*9:30 AM*

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

*X*

*SL*

OVEN TEMPERATURE:

*X*

*09-01-15 X*

FINISH TIME:

*X*

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

*SL 09/01/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 1:53:30 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43941B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/09 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

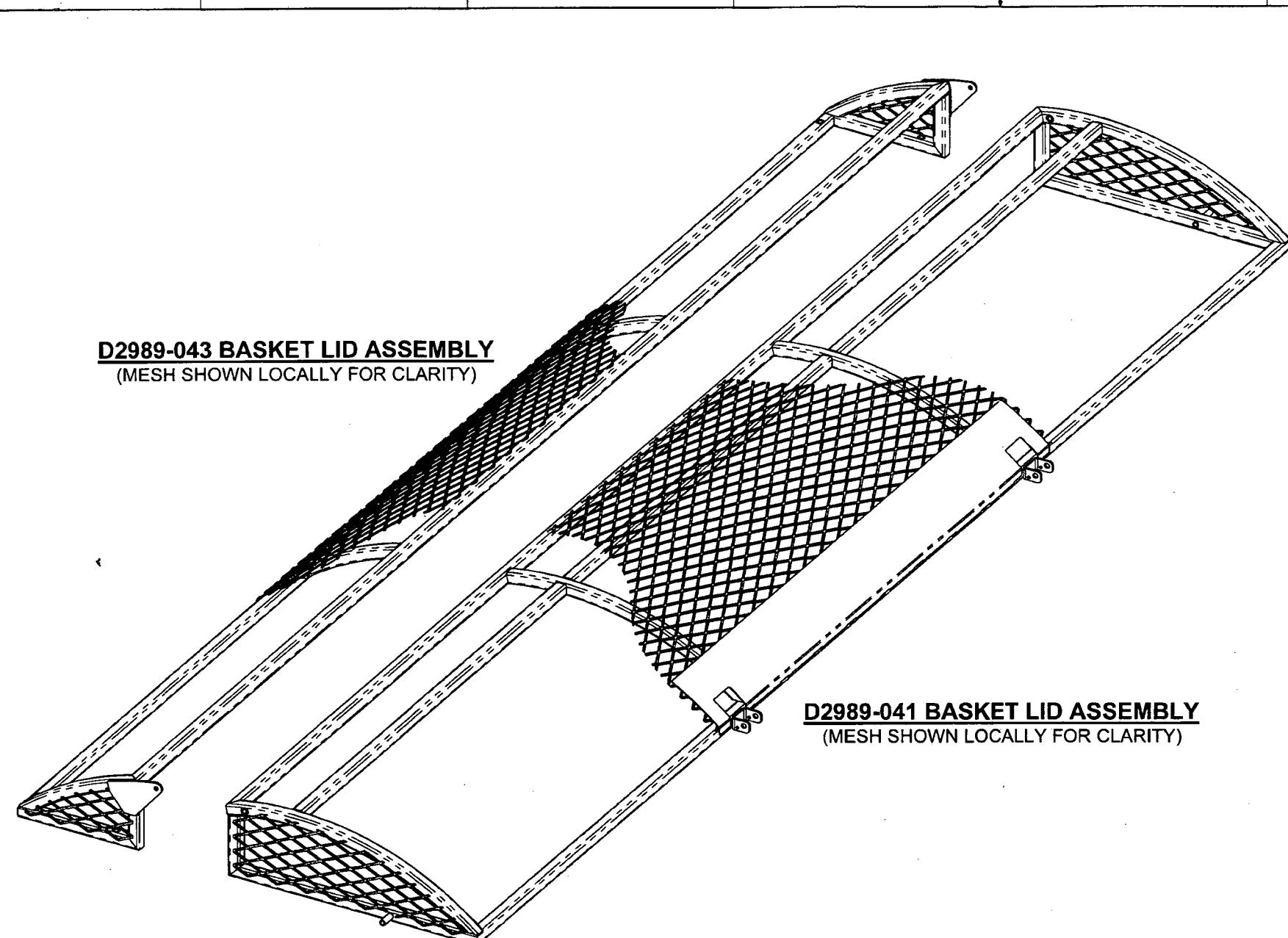
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

D

C

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WORK ORDER  
NO. 43418

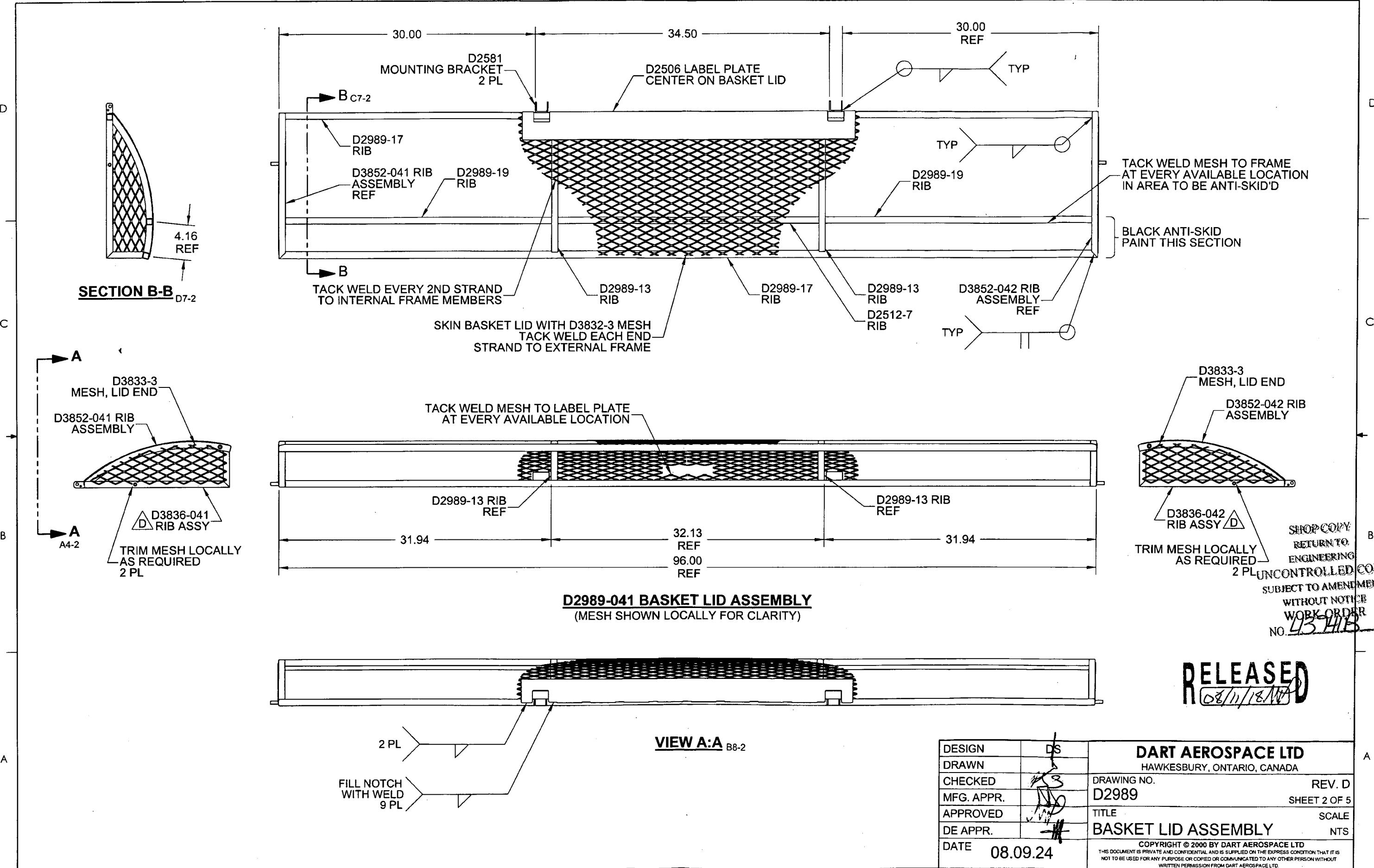
RELEASED  
08/11/18 MHD

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9-15; D3836-042 REPLACES D2989-10-15; D3838-041 REPLACES D2989-1-7; D3838-042 REPLACES D2989-2-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9-10 (NOW ON D3836 DWG), D2989-1-2/-7-15 (NOW ON D3838 DWG) AND D2989-11-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED	WD	TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004



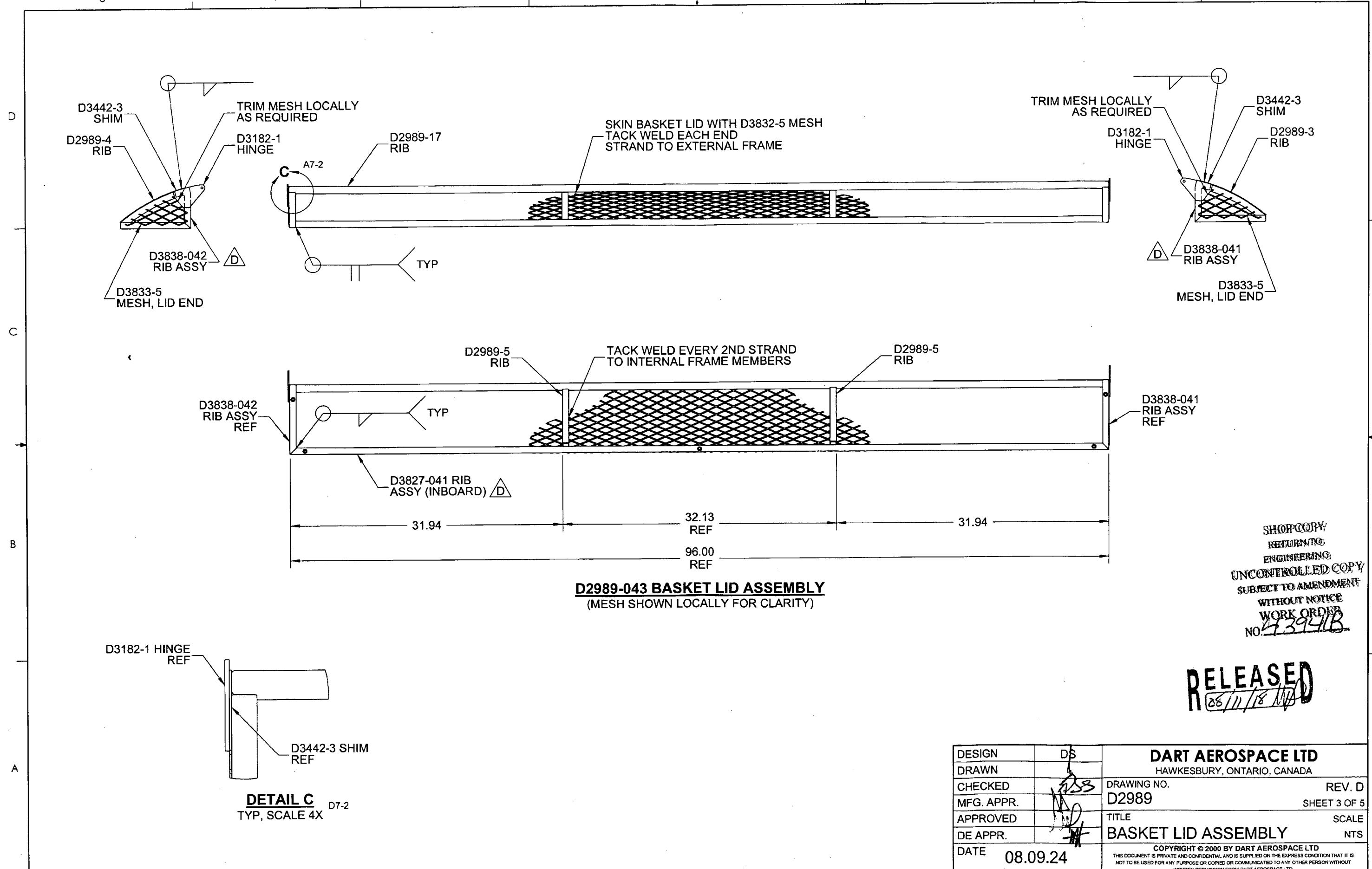
RELEASED  
08/11/2010

## **VIEW A:A**

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	
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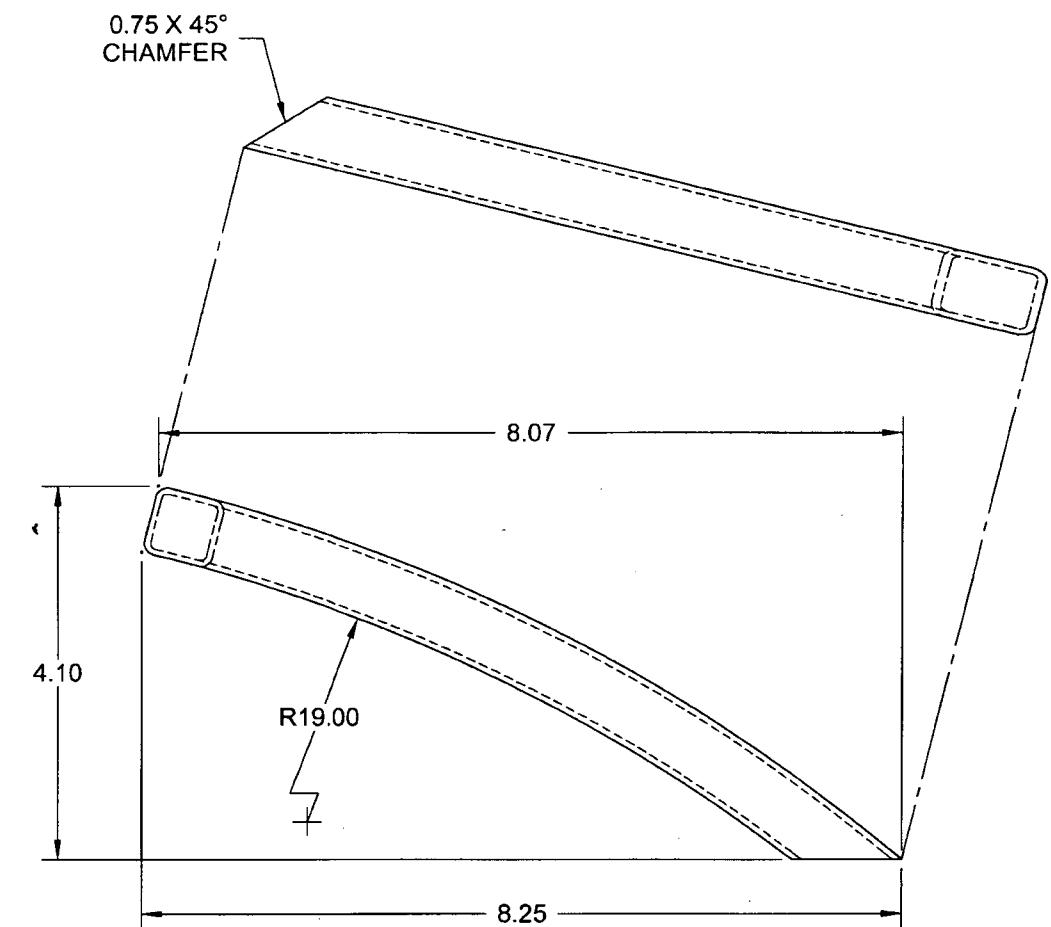


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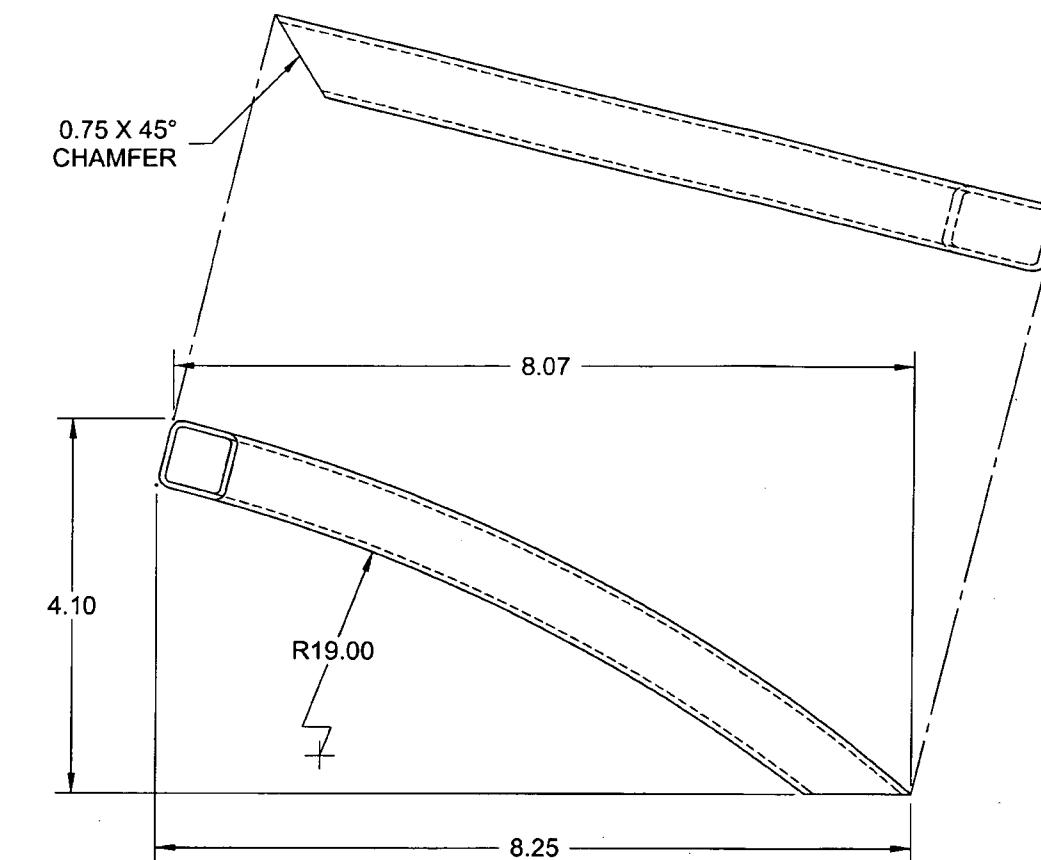
8 7 6 5 4 3 2 1

D

D



D2989-3 RIB



D2989-4 RIB

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WORK ORDER  
NO. 43941B

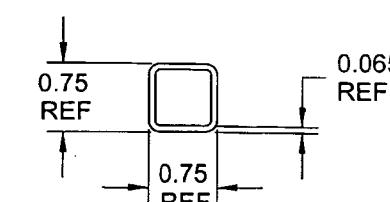
**RELEASED**  
08/11/18 MW

A

A

NOTES:

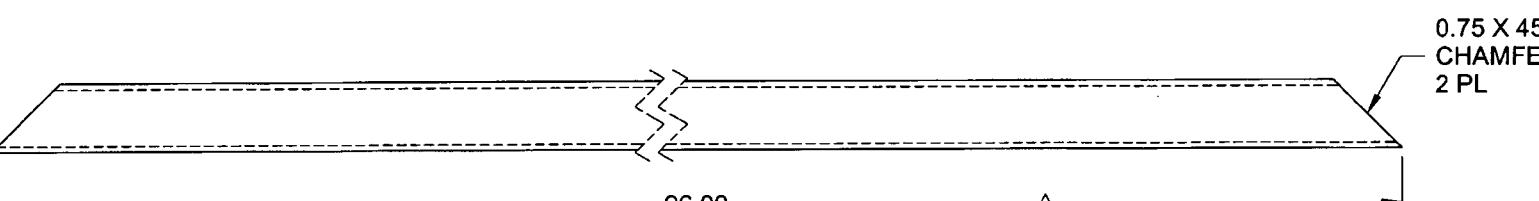
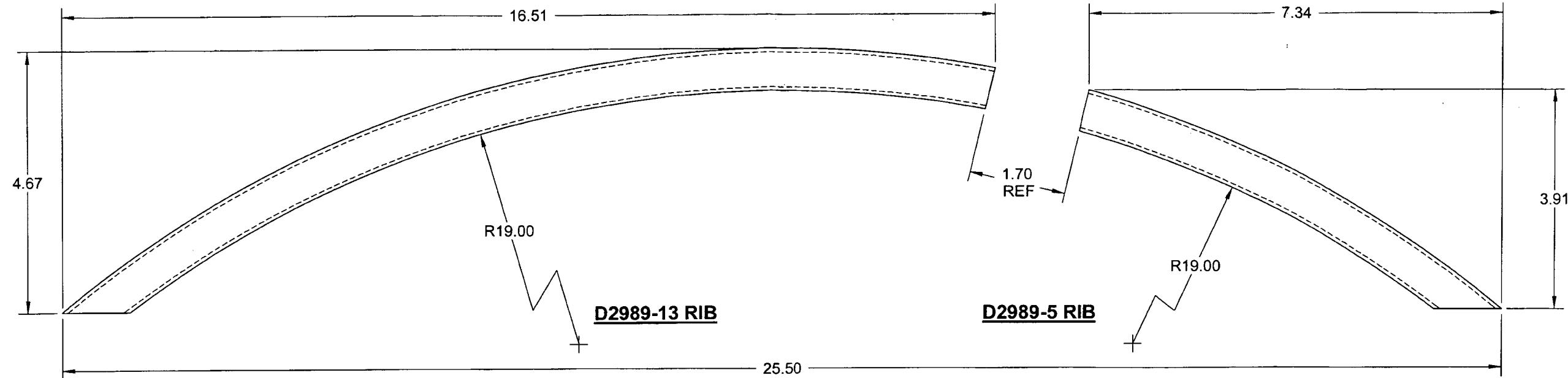
- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



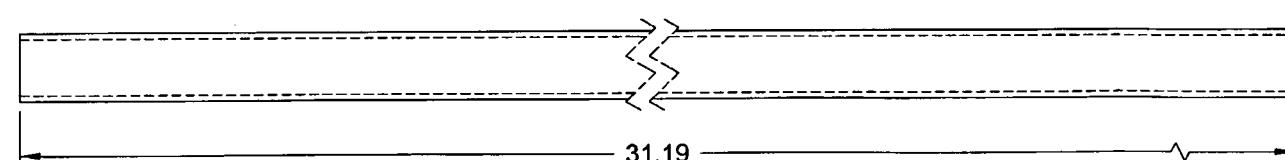
TYPICAL SECTION  
VIEW

DESIGN	DS	<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>DS</u>	DRAWING NO.
MFG. APPR.	<u>MC</u>	REV. D
APPROVED	<u>WV</u>	D2989
DE APPR.	<u>WV</u>	SHEET 4 OF 5
DATE	08.09.24	TITLE
		SCALE
		BASKET LID ASSEMBLY
		NTS
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**D2989-17 RIB**



**D2989-19 RIB**

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WORK ORDER  
NO. 43941B

**TYPICAL SECTION VIEW**

**RELEASED**  
*08/11/18 JWD*

NOTES:  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF. DART SPEC. M304TS0.750W0.065  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD			
DRAWN	<i>✓</i>	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<i>✓</i>	DRAWING NO.			
MFG. APPR.	<i>✓</i>	REV. D			
APPROVED	<i>✓</i>	D2989			
DE APPR.	<i>✓</i>	SHEET 5 OF 5			
DATE	08.09.24	TITLE	SCALE		
		BASKET LID ASSEMBLY			
		NTS			
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